

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020891**Date Inspected:** 21-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Suspender Bracket**Summary of Items Observed:**

On this date Cal-trans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Liu Huajie.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Vertical Shear Plate

PCMK: SA3358

Weld Number: 020

Welder: 067610

WPS-B-T-2114-FCM-1

Component: Vertical Shear Plate

PCMK: SEG3019BC

Weld Number: 006

Welder: 037932

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2114-FCM-1

Component: I Rib

PCMK: SEG3019S

Weld Number: 041, 046

Welder: 066733

WPS-B-T-2233-ESAB

Component: Floor Beam Stiffener

PCMK: SEG3019D

Weld Number: 165

Welder: 067656

WPS-345-SMAW-1G-FCM-REPAIR

WR 20273

Component: Horizontal Diaphragm

PCMK: SEG3019Z

Weld Number: 011

Welder: 066418

WPS-345-SMAW-2G-FCM-REPAIR-1

CWR2755

Component: Floor Beam

PCMK: SEG3019L

Weld Number: 076

Welder: 215553

WPS-345-SMAW-3G-FCM-REPAIR

WR 19769

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Suspender Bracket

PCMK: SB027-110

Weld Number: 003, 004

Welder: 062752

WPS-B-T-2232-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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